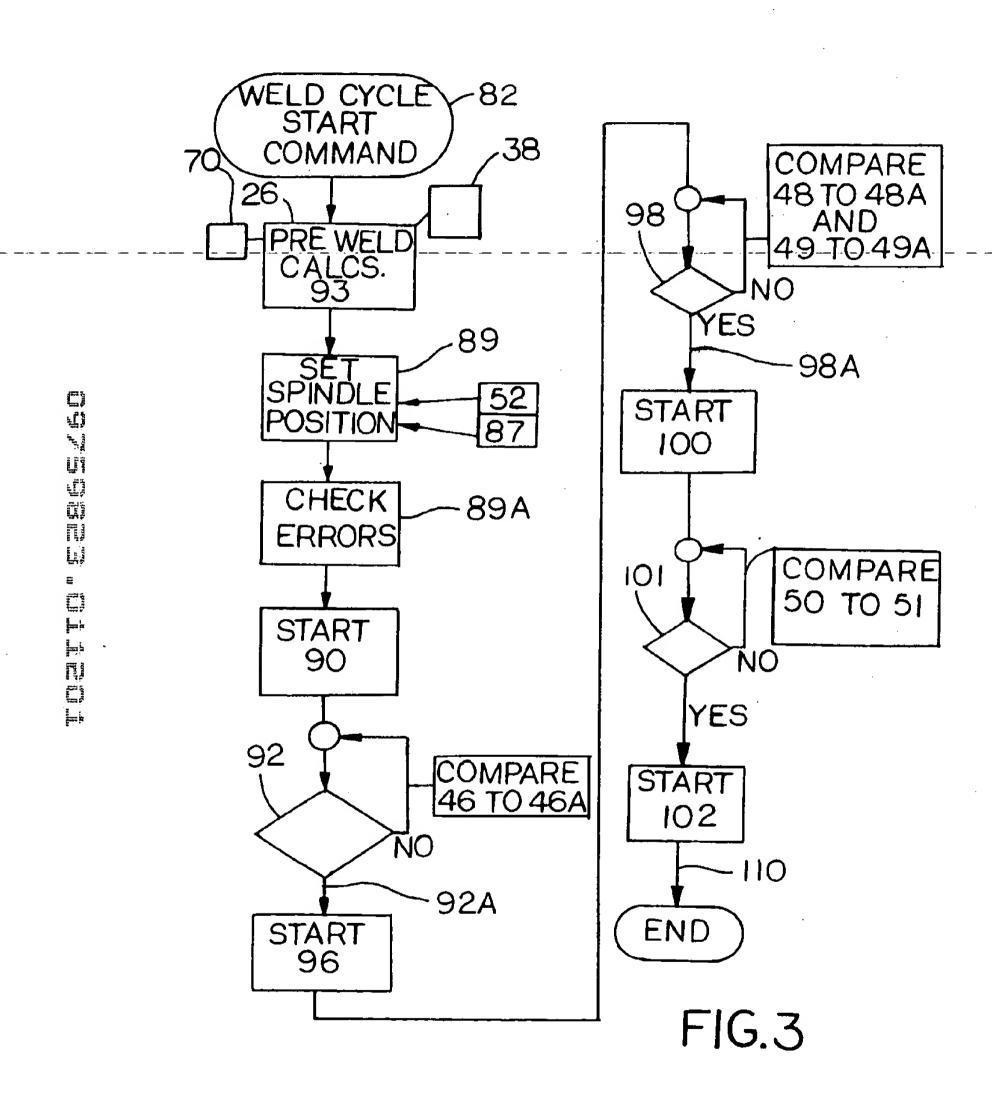


APPROVED

APPROVED	O.G. FIG.	
BY.	CLASS	SUBCLASS
DRAFTSMAN		



APPROVED O.G. FIG. ΒŸ DRAFTSMAN F16.4 MOTOR TACHOMETER 32 POWER AMPLIFIER Σ 68 FEEDBACK CURRENT 30 99 65 64 FEEDBACK AMPLIFIER IN VELOCITY MODE 35 COMMAND CURRENT 62 VELOCITY) AMPLIFIER VELOCITY 69 58 VELOCITY COMMAND + 54

CLASS SUBCLASS YB" DRAFTSMAN DWELL TA FORGE FORCE 83 DESIRED SPEED 53 The said that the line of the said that 2 96B FORCE 81 IN PRE-HEAT TON HEAT PRE-HEAT/HEATING STAGE 96 TIME F16.5 96 A FORCE 79 SPINDLE REVOLUTIONS (RPM) ACCELERATION PHASE -ACTUATOR FORCE 120. 90

APPROVED

INPUT REGISTER 38

REFERENCE NUMBER	DESCRIPTION
6	MATERIAL CONSTANT (mC)
8	GEOMETRIC CONSTANT (gC)
42	DESIRED FINAL POSITION
73	MATERIAL TYPE
75	WORKPIECE WEIGHT
77	GEOMETRIC PROPERTIES
76	LENGTH OF FIRST WORKPIECE
78	LENGTH OF SECOND WORKPIECE
80	DESIRED LENGTH OF FINISHED PRODUCT

FIG.6

DRAFTSMAN

OUTPUT REGISTER 70

REFERENCE NUMBER	DESCRIPTION
39	DESIRED ANGULAR POSITION
44	DESIRED TOTAL SPINDLE ROTATIONS
46	DESIRED ACCELERATION ROTATIONS
48	DESIRED PRE-HEAT ROTATIONS
49	DESIRED HEATING ROTATIONS
50	DESIRED FORGE ROTATIONS
51	ACTUAL FORGE ROTATIONS
53	DESIRED ROTATIONAL SPEED
61	REQUIRED TIME AT PRE-HEAT FORCE LEVEL
63	PRE-HEAT DISTANCE
65	REQUIRED TIME AT HEAT FORCE LEVEL
67	HEAT DISTANCE
69	REQUIRED TIME AT FORGE FORCE LEVEL
71	FORGE DISTANCE
72	ROTATIONAL MOMENT OF INERTIA
74	TARGET UPSET DISTANCE
79	PRE-HEAT FORCE LEVEL
81	HEAT FORCE LEVEL
83	FORGE FORCE LEVEL
120	DESIRED SPINDLE PROFILE

FIG.7